

Work Order ID 93876

93876

Page 1

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 27/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 12-11-27 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3274

D

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A *JD*

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Page 2

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 27/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

0.00

Memo

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: m120854/m122357

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 12-11-29

CF 12-12-05

3 BE 12-12-05

SAD 12-01-10

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 27/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
9-83 13/1/14

114

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

DAS
24
9-83 13-1-10

116

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

1 26 13-1-15

Work Order ID 93876

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Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.00

Quality Control

① SAD 13-01-14

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 M123944

Sikaflex expire date: 13-06-22

Start: 13-1-15 Time: 13:25

Finish: Time:

(Adhere for 12 hours)

CF 13-1-15

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Item ID: D206-642-541

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 27/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control



DP 13-1-16

170

Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

- DC 13/01/16

> CF 13-1-18

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Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 27/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

0.00

190

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod M122130

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 13-01-21

→ CA 13-1-21

DD 13-1-22

DAS
18
9-89

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Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 27/11/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

230 White Gloss(Ref 4.3.5.1) per OSI005 4.3-Alum 0.00

230

Powdercoat

Powder Coating

Memo

0.00

START TIME: 9:00
OVEN TEMPERATURE: 320°
FINISH TIME: 9:30

1 4 13/11/24

240 QC3- Inspect Part Finish 0.00

240

QC

Quality Control

Memo

0.00

1 X 13/11/24

250 HandFinishing 0.00

250

HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 11/11/24

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 11/12/24
Sikaflex expire date: 13/06

1 X 13/11/25

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260
260
QC

QC5- Inspect part completeness to step on W/O

0.00

DAS
13/1/25

Quality Control

Memo

Inspect Nut Plate & Inserts

0.00

270
270
HandFinish

HAND FINISHING RESOURCE #1

0.00

Hand Finishing

Memo

1-Install wearpads & gaskets as per Dwg D3274.

0.00

2-Install ring as per Dwg D3274

A/RSikaflex-291 AA 123444
Sikaflex expire date: 13/06

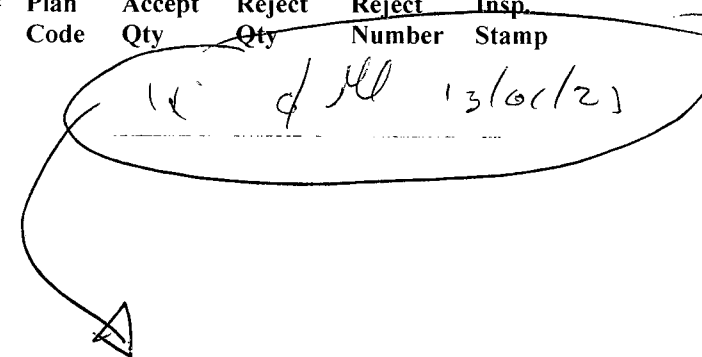
3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 101A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 AA 123444
Sikaflex expire date: 13/06



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Item ID: D206-642-541

Revision ID:

Item Name: Replacement Skidtube

Start Date: 27/11/2012 Start Qty: 1.00

Required Date: 06/12/2012 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

DAS
15
8-89
13.128

290

Identify as per dwg & Stock Location: _____

0.00

290

Packaging

Memo

0.00

Packaging

PP 93867

DAS
06
8-89

13/11/30

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

13/11/31

13-01-13

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Work Order ID: 93876

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	83.0000	1				
D2600-1-190									**				
Extrusion Round 3" 206													

12-11-29

Location	Loc Qty	Loc Code
HALL	43	
69622	43	
LG	40	
76912	40	

D3285-1
 D3285-1
 Cap

Manufactured	No	110	Each	21.0000	1	**
--------------	----	-----	------	---------	---	----

1

BE 12-12-05

Location	Loc Qty	Loc Code
LG002	21	
52511	1	
52647	20	

D3282-041

Manufactured	No	150	Each	4.0000	1	**
--------------	----	-----	------	--------	---	----

D3282-041

Float Web (206L/407)

1 GF 13-1-15

Location	Loc Qty	Loc Code
LG	4	
91988	4	

B93487

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Work Order ID: 93876

93876

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

202.0000

12

12

D2649

Cross Bolt Spacer

BE 13-01-18
*B 93663 *12*

Location

Loc Qty

Loc Code

LG001

1

90967

1

LG002

201

82813

40

85586

4

86912

3

88529

15

90333

7

90497

6

91632

120

92194

6

D3275-1

Manufactured No

190

Each

145.0000

12

12

D3275-1

Crossbolt Spacer

BE 13-01-18

Location

Loc Qty

Loc Code

LG002

145

66930

1

85418

1

87713

143

12

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Work Order ID: 93876

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

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D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1.640.000

2

2

CR3212-4-03

Cherry Rivet

**

13/01/24

Location

Loc Qty

Loc Code

ST328

804

114859

210

123265

500

123301

94

ST331

836

110139

2

119017

834

D3415-041

Manufactured

No

250

Each

13.0000

1

1

D3415-041

Nut Plate

**

13/01/24

Location

Loc Qty

Loc Code

ST044

13

82151

13

393330

CCR264SS3-3

Purchased

No

250

Each

468.0000

2

2

CCR264SS3-3

Cherry Rivet

**

13/01/24

Location

Loc Qty

Loc Code

ST327

468

117849

5

119017

188

122973

73

123265

202

x2

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

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D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

389.0000

78

78

**

AI S4-1032-130

Insert

13/01/2012

Location

Loc Qty

Loc Code

ST279

389

AI124080

X70

119084

116

120671

89

120807

36

120837

8

121269

140

D3536-15

Manufactured

No

270

Each

21.0000

1

1

**

D3536-15

Gasket

13/01/2012

Location

Loc Qty

Loc Code

FG

2

85604

2

FP001

17

86253

9

93199

8

FP002

2

73318

1

81343

1

D3536-23

Manufactured

No

270

Each

24.0000

1

1

**

D3536-23

Gasket

13/01/2012

Location

Loc Qty

Loc Code

FG

2

85295

2

FP002

22

74510

1

83377

1

89928

20

X1

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Work Order ID: 93876

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

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D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35

Manufactured No

270

Each

26.0000

1

1

D3536-35

Gasket

**

M 13/01/24

Location

Loc Qty

Loc Code

FG

2

93911

xl

89650

2

FP001

1

86251

1

FP002

23

82065

2

90843

8

90844

13

D3536-39

Manufactured No

270

Each

21.0000

1

1

D3536-39

Gasket

**

M 13/01/24

Location

Loc Qty

Loc Code

FP001

21

82252

1

85870

7

92160

13

xl

D3535-15

Manufactured No

270

Each

41.0000

1

1

D3535-15

Wearshoe

**

M 13/01/20

Location

Loc Qty

Loc Code

FP001

41

85291

2

86230

10

93045

29

xl

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Parent Item Name: Replacement Skidtube

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D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-35

Manufactured No

270

Each

22.0000

1

1

D3535-35

Wearshoe

**

u 13/6/12d

Location

Loc Qty

Loc Code

FP001

22

B93799

XL

67598

1

70815

1

79849

1

86191

1

90092

5

92343

13

D3535-39

Manufactured No

270

Each

21.0000

1

1

D3535-39

Wearshoe

**

u us1012a

Location

Loc Qty

Loc Code

FP001

21

69759

1

81359

4

85869

6

87182

10

D3535-23

Manufactured No

270

Each

40.0000

1

1

D3535-23

Wearshoe

**

u 13/01/25

Location

Loc Qty

Loc Code

FP001

40

86232

1

89963

13

90518

13

93181

13

XL

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

93876

D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

18.0000

1

1

D3537-3

Wearpad

**

all 13/01/25

Location

Loc Qty

Loc Code

FG

8

B93366

x1

86237

8

FP002

10

78836

1

90147

9

D3537-1

Manufactured No

270

Each

71.0000

9

9

D3537-1

Wearpad

**

all 13/01/25

Location

Loc Qty

Loc Code

FP001

57

91645

33

B93945

x9

91668

24

FP002

14

83254

1

83255

3

87697

1

88562

9

AN960C10L

NAS1149C0332

Purchased

No

270

Each

21.0000

80

80

AN960C10L

washer

M123759

**

1x80 all 13/01/25

Location

Loc Qty

Loc Code

ST245

21

107534

21

AN960C416

NAS1149C0463

Purchased

No

270

Each

0.0000

1

1

AN960C416

washer

M119097

**

(x1) all 13/01/25

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Picklist Print

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93876

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,237.000

2

2

**

13/01/25

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

2

80369

2

ST061

1225

72229

4

76277

13

83608

460

85222

268

91325

480

VZ

AN3C4A

Purchased

No

270

Each

2,953.000

80

80

**

13/01/25

AN3C4A

BOLT

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350

2751

123759

2751

ST513

182

120187

31

120521

28

120769

38

121205

61

121556

8

122151

2

122416

4

122814

2

123021

8

1124221

V80

Picklist Print

November-27-12 8:32:36 AM

Page 9

Work Order ID: 93876

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

93876

D206-642-541

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

443.0000

1

1

**

13/01/25

AN4C5A

BOLT

Location

Loc Qty

Loc Code

ST355

443

112243

129

119017

6

122599

108

123265

200

X1

D2646

Manufactured

No

270

Each

152.0000

1

1

**

13/01/25

D2646

Aft Cap

Location

Loc Qty

Loc Code

FG

2

90495

2

FP002

150

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

79562

2

81974

10

85443

2

85848

4

90495

16

91189

100

X1

Packlist Print

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Page 10

Work Order ID: 93876

93876

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 27/11/2012

Required Date: 06/12/2012

Start Qty: 1.00

Required Qty: 1.00 /

D3413-1

Manufactured No

270

Each

16.0000

1

1

D3413-1

**

11/16/12

Ring

Location

Loc Qty

Loc Code

ST421

12

B91117

✓

88025

10

90506

2

ST464

4

80224

4

DART

RELEASED

07.02.12
DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

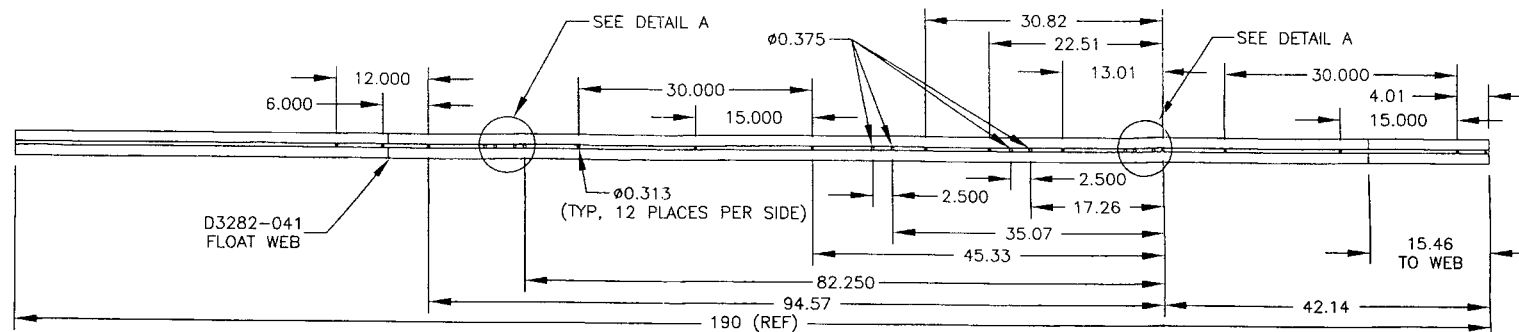
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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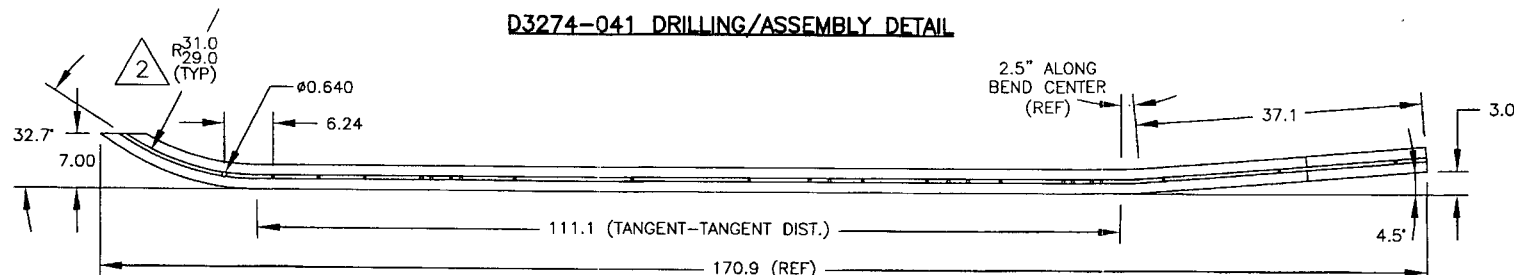
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93876

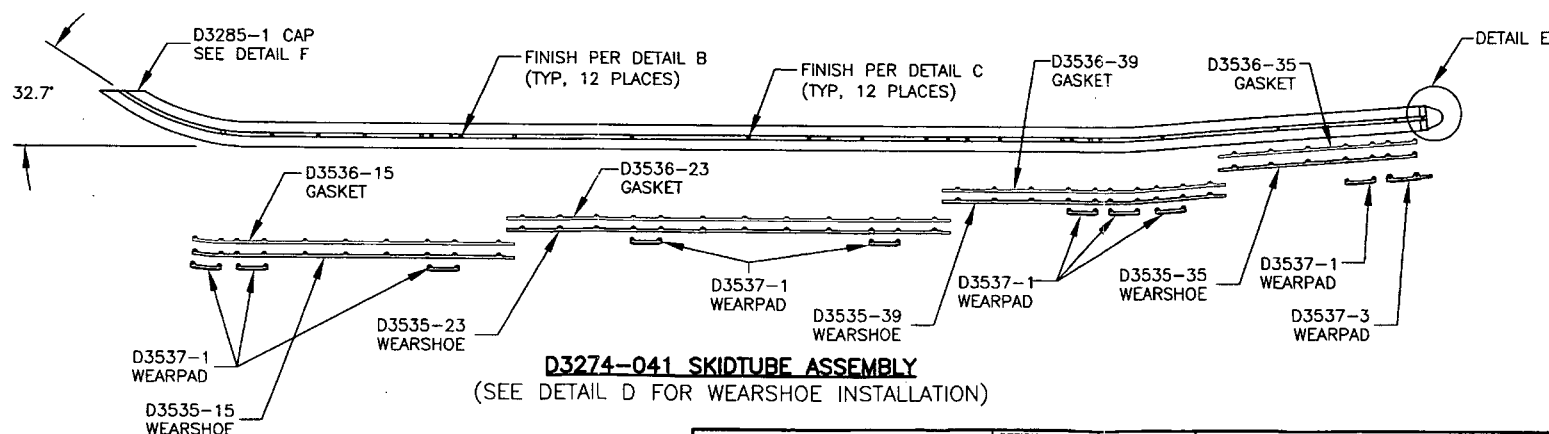
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

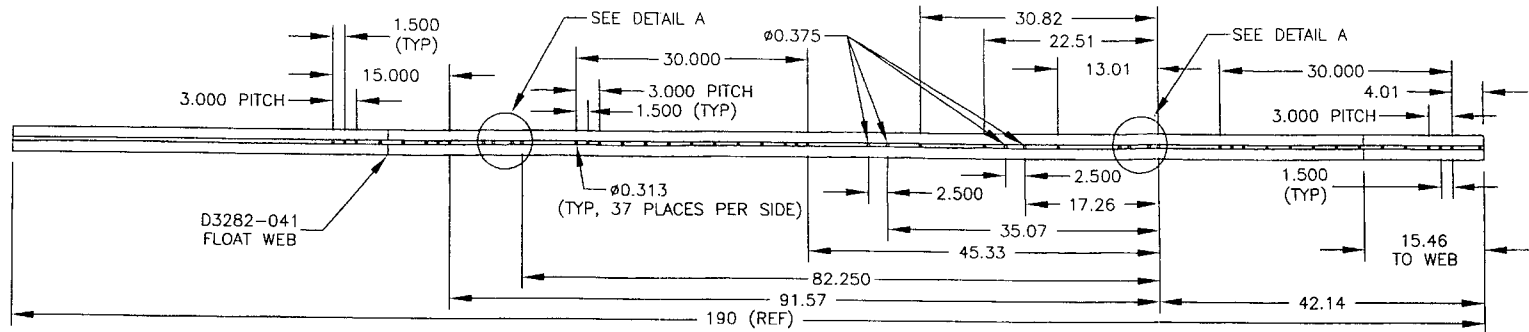
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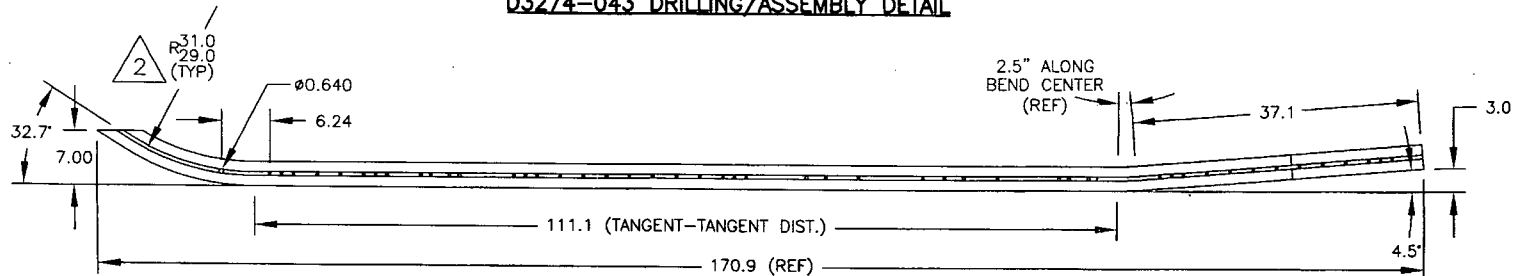
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CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	
				REV. D SHEET 2 OF 4 SCALE 1:15

93874

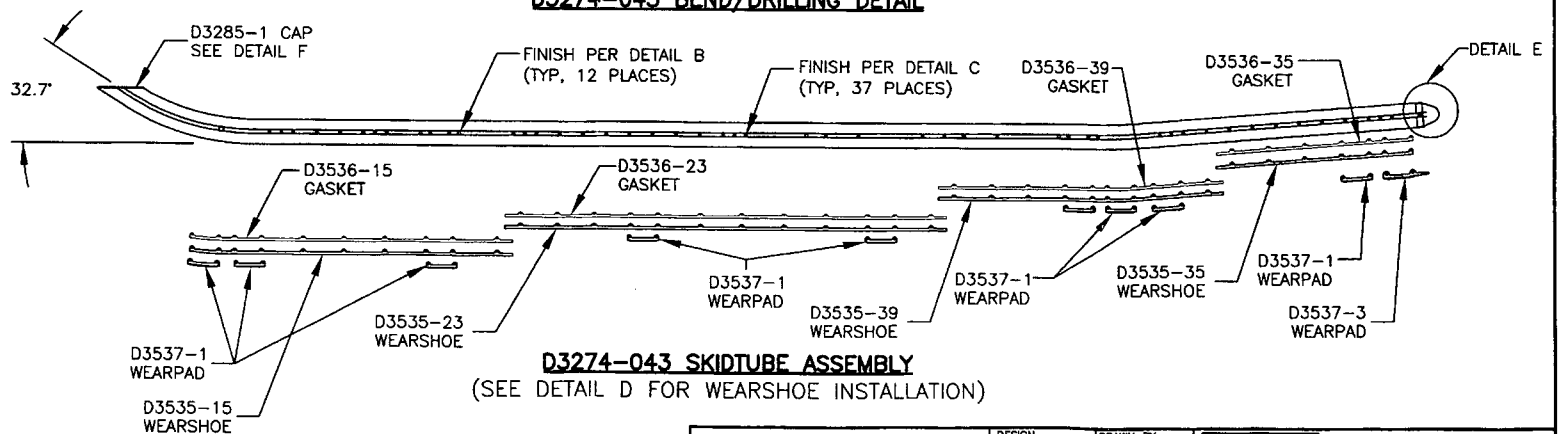
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

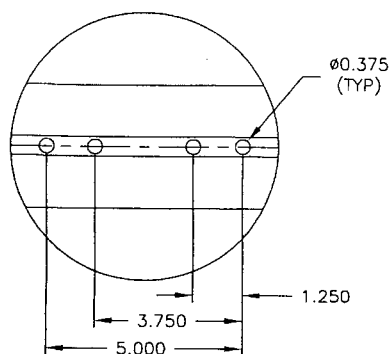
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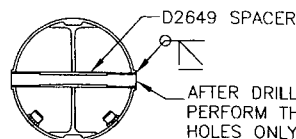
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. D
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 3 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

DETAIL A: DRILL DETAIL

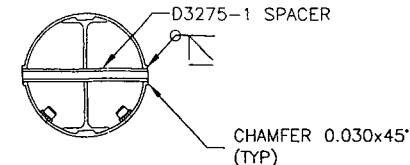


DETAIL B FOR $\phi 0.375$ HOLES ONLY

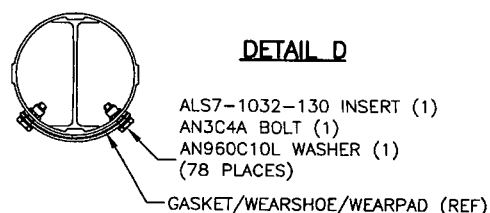


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO $\phi 0.313 \times 0.75$ DEEP

DETAIL C FOR $\phi 0.313$ HOLES ONLY

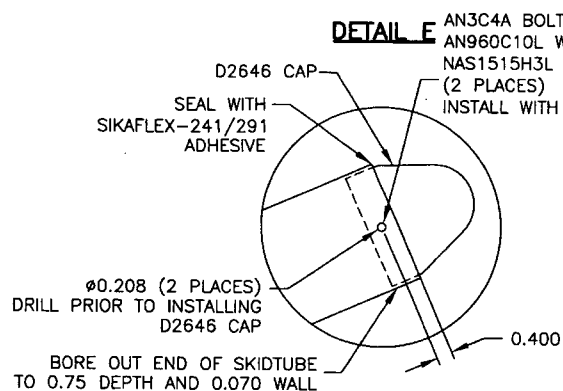


DETAIL D



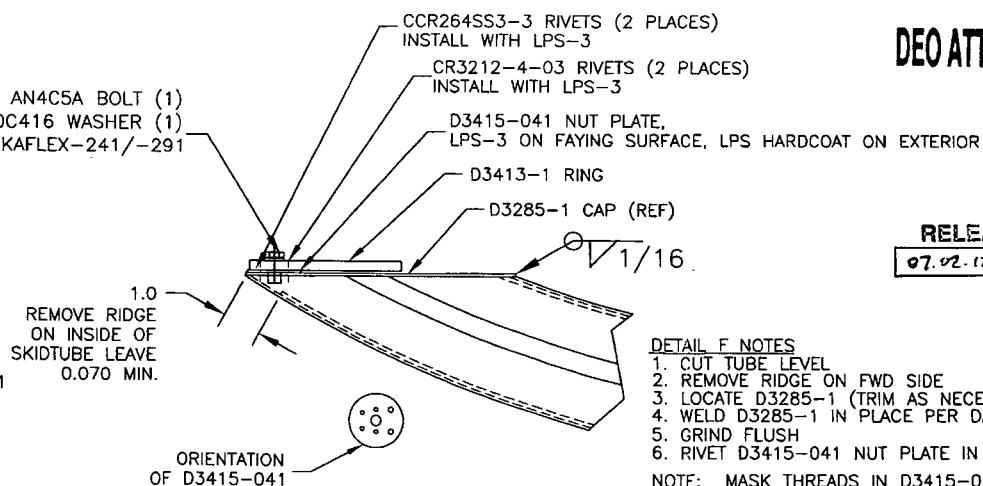
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DETAIL F: END FINISHING DETAIL



- 1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED

07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

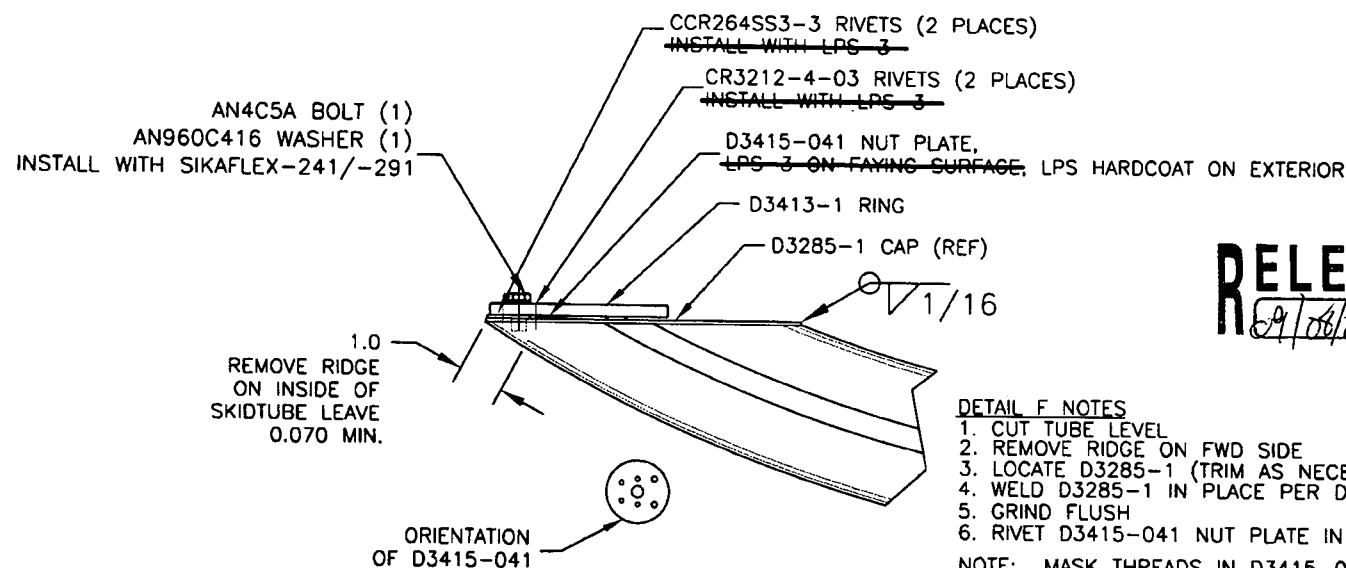
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

NO. 311

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 910721
Part #: A206-642-151
Description: St. d. tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier David Daniel Date of Test Coupon 13.01.09
Welder Barclay Elliott Date of Test Coupon 13.01.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

